

Work Order ID 81459

Wednesday, March 14, 2012 11:01:35 AM

81459

Page 1

Item ID: D3910-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug

Start Date: 3/14/2012 Start Qty: 40.00

Required Date: 3/30/2012 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: ME

Date: 12-03-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3910	B

100

0.00

100

Bandsaw

Jcaspa Bandsaw

Memo

Cut to 1.450" Long

cut @ metec

CZ 12/03/15

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV:

DWG REV:

P/O: 16451

DEBURR

issue P/O to metec

#4

CZ 12/03/15 40

Machine as per drawing D3910-REV. B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

81459

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Customer:

40

40

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

120

0.00

rec'd + inspect for transit damage
attached COC to W/O

0.00

130

0.00

8.2/3/29

0.00

140

0.00

40xØ m/k 12/03/29

W/O:		WORK ORDER CHANGES					
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Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 3/14/2012 **Start Qty:** 40.00

40

Required Date: 3/30/2012 **Req'd Qty:** 40.00

40

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Memo

S-1h55

0.00

Powdercoat

T- 320°F
F- 2125

m120222

Powder Coating

160

QC3- Inspect Part Finish

0.00

160

Memo

0.00

QC

Quality Control

170

Identify as per dwg & Stock Location: S7 507

0.00

170

Memo

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
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Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 3/14/2012 **Start Qty:** 40.00

40

Required Date: 3/30/2012 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

CL12103/30

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, March 14, 2012 11:01:35 AM

Page 1

Work Order ID: 81459

Parent Item: D3910-3

Start Date: 3/14/2012

Required Date: 3/30/2012

Parent Item Name: Crosstube Lug

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
03-23 JLM VERIFIED BY:DD

IPP REV:B AS PER REV B 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			100	f	321.6600	0.13	5.4736842		02/03/15	

Location

Loc Qty

Loc Code

MAT006

321.66

43722

161.5

45800

1

68331

159.16

5.48

D 3910-3 P

X 40

06/13/17 (40)

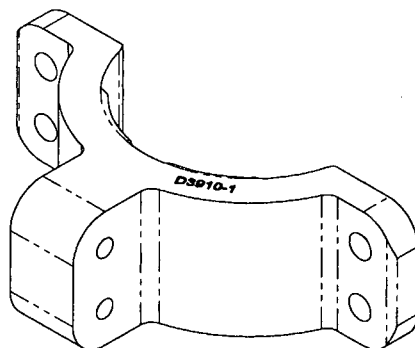
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

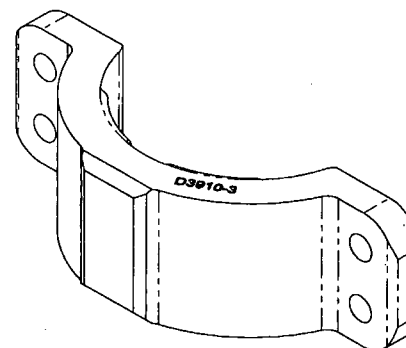
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D3910-1 X-TUBE LUG







D3910-3 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

81459

RELEASED
2010-03-22
MD

B	Ø 0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2			JPH	10.03.16
A	NEW ISSUE			JPH	10.03.04
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH				
CHECKED			DRAWING NO.	REV. B	
MFG. APPR.			D3910	SHEET 1 OF 3	
APPROVED			TITLE	SCALE	
DE APPR.			X-TUBE LUG (350)	NTS	
DATE	10.03.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

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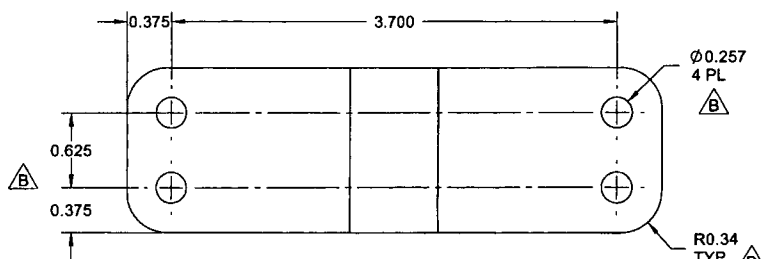
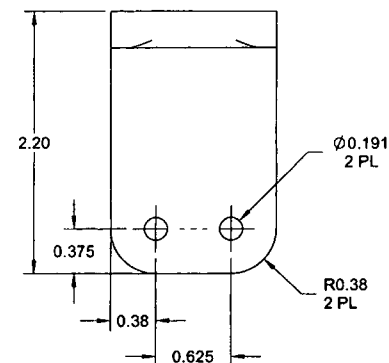
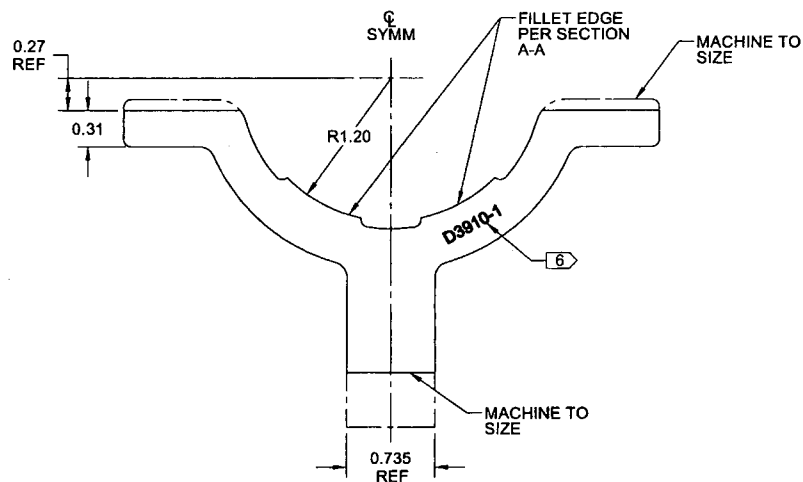
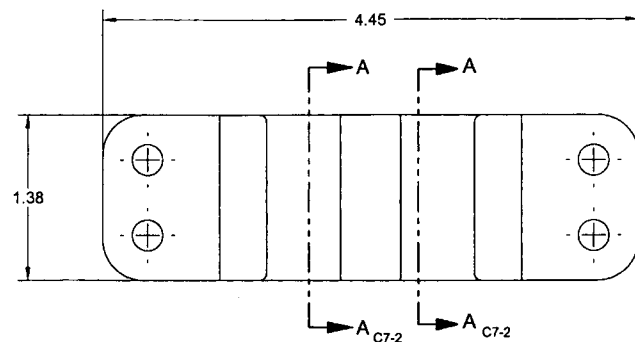
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ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG

81459

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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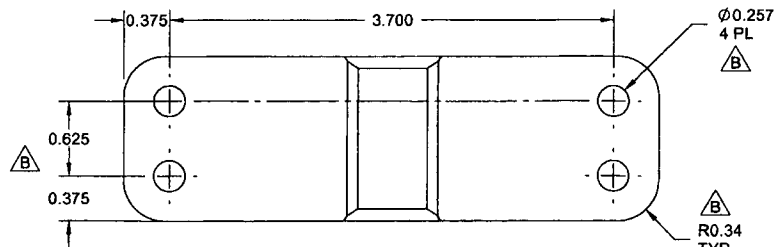
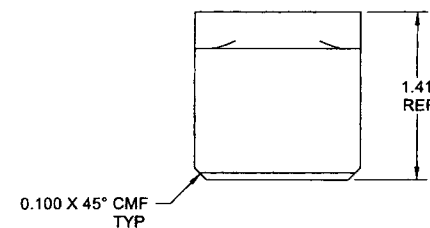
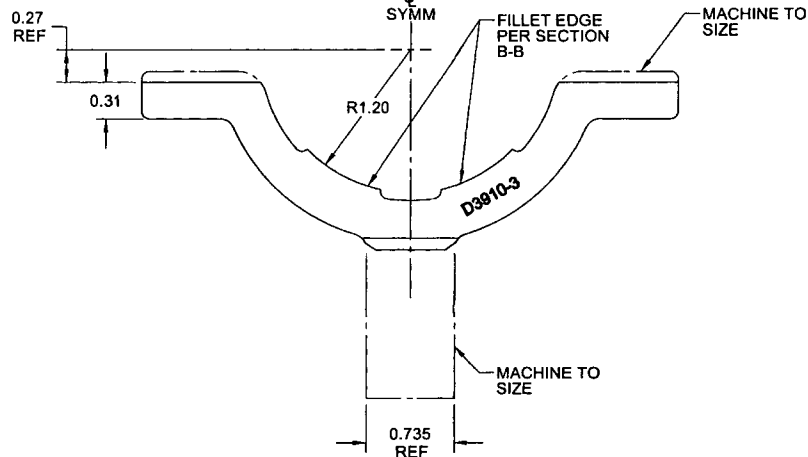
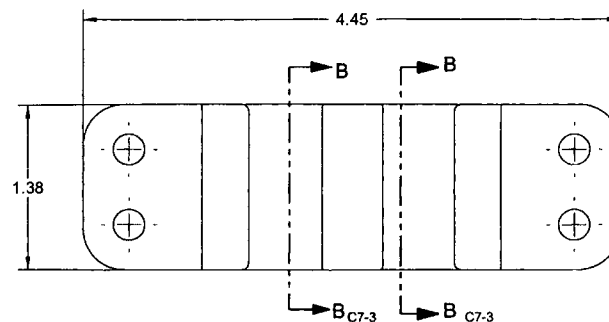
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

#81459

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3910	REV. B
MFG. APPR.		TITLE X-TUBE LUG (350)	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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Dart Aerospace Ltd

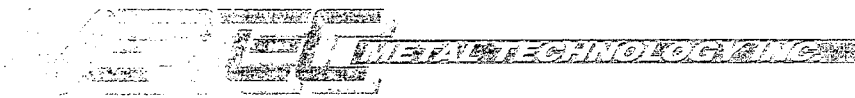
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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18526
Date: Mar 23, 2012
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO16451	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Mar 23, 2012

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-1 Crosstube Lug as per drawing D3910 REV.B B81474	Each	40		
D2230-3 Mounting Lug as per drawing D 2230 REV.G B81558	Each	200		200
D4091-1 Lug as per drawing D4091 Rev.AB81461	Each	30		30
3910-3 Crosstube Lug as per drawing D3910 REV.B B81459	Each	40	40	
8/26/28				
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3910-3	Crosstube Lug	16451

MATERIAL: supplied by DART B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, March 23, 2012